

13. The process of claim 12, wherein the oxycodone hydrochloride composition having less than 25 ppm 14-hydroxycodeinone is isolated from the solution by crystallization and filtration.

14. The process of claim 10, wherein the oxycodone hydrochloride composition having less than 25 ppm 14-hydroxycodeinone is formed by hydrogenation. 5

15. The process of claim 10 comprising reacting the oxycodone base composition with an acid having a higher pH than hydrochloric acid to form an corresponding acid addition salt of oxycodone, and converting the acid addition salt of oxycodone to oxycodone hydrochloride. 10

16. An oxycodone hydrochloride composition which comprises at least 95% oxycodone hydrochloride, 8 $\alpha$ ,14-dihydroxy-7,8-dihydrocodeinone, less than 5 ppm of codeinone, 15 and less than 25 ppm of 14-hydroxycodeinone.

17. The oxycodone hydrochloride composition of claim 16, having less than 5 ppm of 14-hydroxycodeinone.

18. The oxycodone hydrochloride composition of claim 16, wherein the composition has a lower limit of 14-hydroxycodeinone of 0.25 ppm. 20

19. The oxycodone hydrochloride composition of claim 16, wherein the composition has a lower limit of 14-hydroxycodeinone of 0.5 ppm.

20. The oxycodone hydrochloride composition of claim 16, wherein the composition has a lower limit of 14-hydroxycodeinone of 1 ppm. 25

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